

Date: Friday, 8/3/2007 10:01:26 AM  
 User: Eric Charbonneau

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STA 129 BRACKET
Job Number	33601			
Estimate Number	11642			
P.O. Number	:		Part Number	D29901
This Issue	8/3/2007	S.O. No. :	Drawing Number	D2990 REV B
Prsht Rev.	NC		Project Number	N/A
First Issue	7/17/2007	Type : SMALL /MED FAB	Drawing Revision	B
Previous Run	:		Material	:
Written By	<u>EC 07.08.03</u>		Due Date	8/10/2007
Checked & Approved By	:		Qty:	<u>10</u>
Comment	Est. A 01.31.01 New Issue EC est B 07.08.03 waterjet blank EC		Um:	Each

## Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"	
Comment: Qty.: 0.9913 f(s)/Unit Total : 6.9391 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: <u>4102508</u> SAV 07/08/03 <u>10</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per template DT8547 ***(prog DT8547)*** Dwg Rev: <u>NA</u> Prog Rev: <u>NA</u> 2-Deburr if necessary <u>SAV 07/08/03</u> <u>10</u>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA107 <u>8.6 07/08/13</u> <u>10</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>8.6 07/08/13</u> <u>10</u>			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <u>SD 01.08.13</u> <u>10</u>			

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Job Number: 33601		Part Number: D29901
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>S.F 07/08/13</i>
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr		
7.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		<i>SG 07.08.15 (8)</i>
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
 <i>MFB</i>		 <i>07-08-15 (8)</i>
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
9.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		<i>EP 07/08/16 (8)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE
		 <i>107.08.17</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 <i>11 07/08/16</i>

DART AEROSPACE LTD	Work Order:	33601
Description: STA 129 Bracket	Part Number:	D2990-1
Inspection Dwg: D2990 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	07/08/11	Date:	07.08.12	Date:	N/A

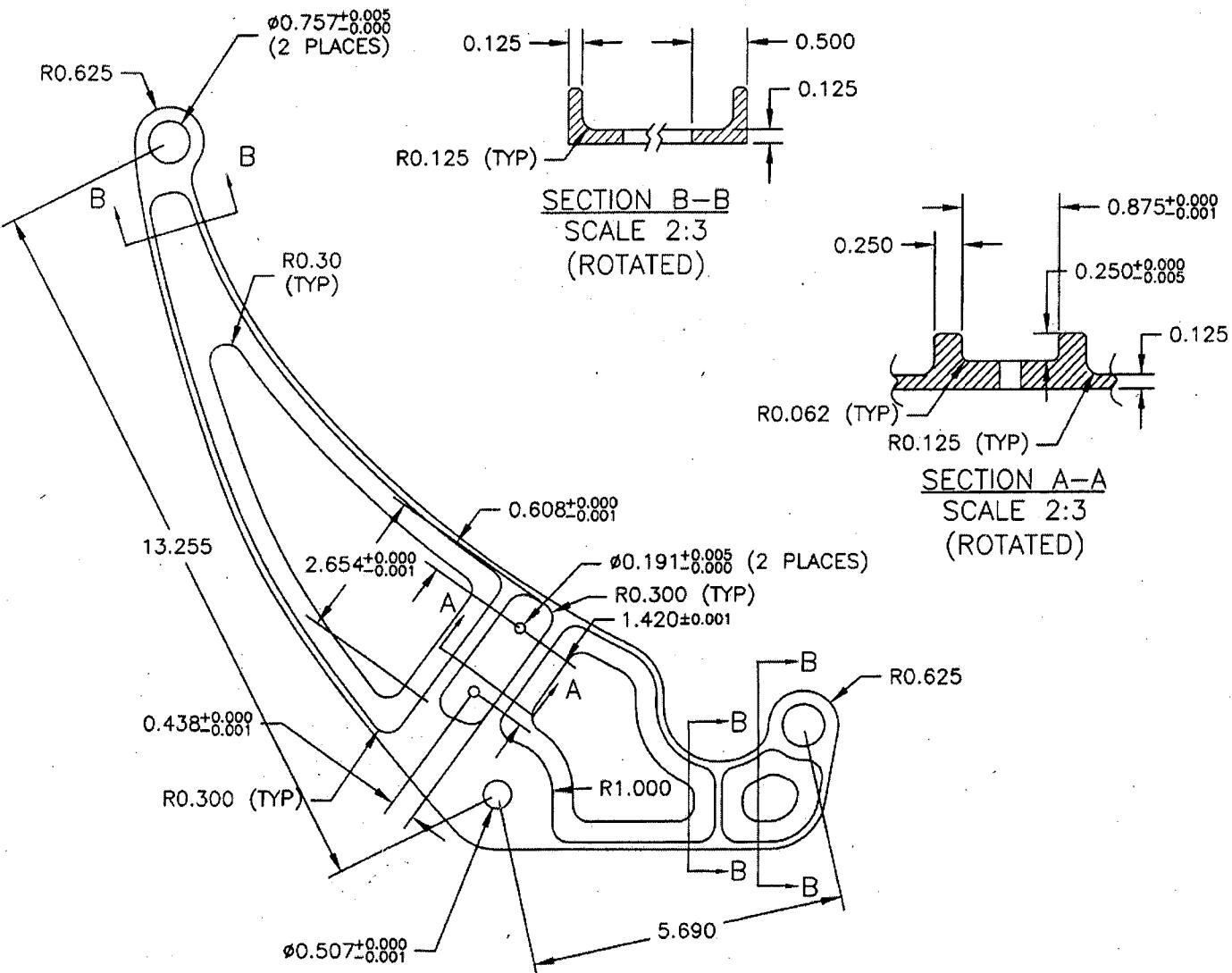
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.03.08	Dwg Rev. change	KJ/JLM	

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2990	REV. B SHEET 1 OF 2
DATE 05.01.20		TITLE STA 129 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	05.01.20	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



### D2990-1 BRACKET (SHOWN), D2990-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2990.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 33601

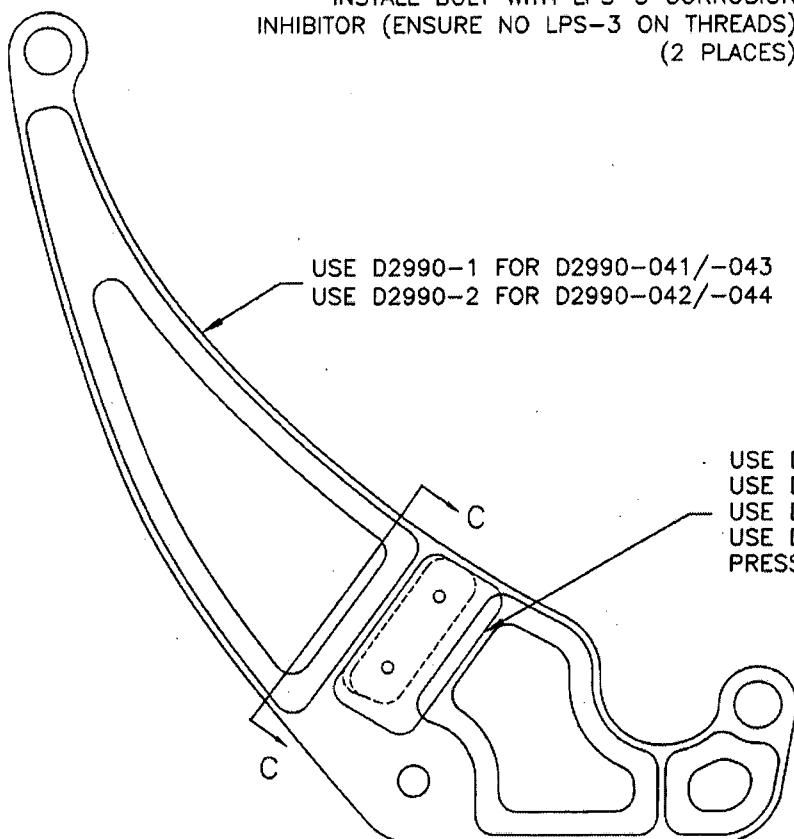
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2990
DATE 05.01.21	TITLE	SCALE 1:3

RELEASED

05.03.11 *[Signature]*

SECTION C-C  
SCALE 1:3  
(ROTATED)

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*33601*

D2990-041/-043 BRACKET ASS'Y (SHOWN),  
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3